

Work Order ID 63510

Wednesday, November 03, 2010 11:13:32 A

Page 1

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 11/3/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 1/4/2011 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-11-03 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3272	Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG002

Swaluz

001

Eurocopter OK for BG 10/11/24

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R ☐ Aluminum Rod

*MID 8136
M114877*

3-Grind End Plate flush

10-11-16 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Start Date: 11/3/2010 Start Qty: 5.00

Required Date: 1/4/2011 Req'd Qty: 5.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				5	0	BERO/11/18	
130  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				5	0		

W/O:		WORK ORDER CHANGES					
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Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

5 PR 10-11-18

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R ☐ Aluminum Rod ☐ m108436

6-Grind End Plate flush

7-Install last rivet as per Dwg.

10-11-19

5

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Start Date: 11/3/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 1/4/2011 Req'd Qty: 5.00



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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				5	0	3E10/11/22	
200 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
210 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							

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Revision ID: Stop 
Item Name: Heli-Access-Step, Long LH
Start Date: 11/3/2010 Start Qty: 5.00  Cust Item ID:
Required Date: 1/4/2011 Req'd Qty: 5.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 115291</i> Memo START TIME: <i>8:30</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>9:00</i>	0.00 0.00				<i>5</i>	<i>10-11-23</i>		
230  HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>M 115790</i> Memo	0.00 0.00		<i>=> M 10/11/23</i>		<i>5</i>	<i>Ø</i>		
240  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>86/11/25</i>		<i>25</i> <i>LM</i>			

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Customer:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/11/24 SD SP

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8 w/ulgr

(XJ)
44

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311

Location: Pail

Reub

10/11/29 SD SP

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/11/29 [Signature]
MF
10-11-29

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NOTE: Date & initial all entries

Wednesday, November 03, 2010 11:13:36 AM

Required Date: 1/4/2011.

Required Qty: 5.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3067-1 		Manufactured	No			110	Each	136.0000	1	5		10.11.16	
End Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				136					
					60141			5					
					<u>62664</u>			131					
D3219-1 		Manufactured	No			110	Each	61.0000	2	10		10.11.16	
Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				61					
					<u>61204</u>			61					
D3272-1 		Manufactured	No			110	Each	0.0000	1	5		10.11.15	B63506
Step													
D3065-041 		Manufactured	No			180	Each	162.0000	1	5		10.11.15	B63506
Step Leg Assembly Hi													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST				134					
					63324			134					
				WA				28					
					61216			3					
					<u>62224</u>			25					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 63510

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LP

Start Date: 11/3/2010

Required Date: 1/4/2011

Start Qty: 5.00

Required Qty: 5.00

D3066-1 Manufactured No 180 Each 87.0000 2 10



Spacer



10.11.19

Location

Loc Qty

Loc Code

WA

87

62662

87

10

D3067-1 Manufactured No 180 Each 136.0000 1 5



End Plate



10.11.19

Location

Loc Qty

Loc Code

WA

136

60141

5

62664

131

5

MS20600-AD4W4 Purchased No 180 Each 1,875.000 16 80



Rivets



10.11.19

Location

Loc Qty

Loc Code

ST321

1875

113368

38

114181

11

114718

2

115573

147

115640

677

116022

1000

80

AN3-35A Purchased No 250 Each 139.0000 2 10



Bolt



10/11/24 5x

Location

Loc Qty

Loc Code

ST353

139

115457

39

115936

100

10

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Work Order ID: 63510

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 11/3/2010

Required Date: 1/4/2011

Start Qty: 5.00

Required Qty: 5.00

AN4-13A Purchased No

250 Each

413.0000

8

40



Bolt

Location

Loc Qty

Loc Code

ST357

300

115936

300

40

ST358

113

115159

113

AN5-36A Purchased No

250 Each

147.0000

2

10



Bolt

Location

Loc Qty

Loc Code

ST340

100

115936

100

10

ST341

47

114292

5

114941

42

AN960JD10 NAS1149D0363J Purchased No

250 Each

8.0000

4

20



Washer

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

AN960JD416 NAS1149D0463J Purchased No

250 Each

24.0000

16

80



Washer

Location

Loc Qty

Loc Code

ST300

24

113288

24

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 63510

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LF

Start Date: 11/3/2010

Required Date: 1/4/2011

Start Qty: 5.00

Required Qty: 5.00

AN960JD516 NAS1149D0563J Purchased No

250 Each

34.0000

4 1 20



Washer



1114742 10/11/2010

Location

Loc Qty

Loc Code

ST 34
103694 18
107534 12
109287 4

D2230-3 Manufactured No

250 Each

90.0000

4 1 20



Aug



B62997 10/11/2010
B63544 10/11/2010

Location

Loc Qty

Loc Code

ST476 90
55452 2
62660 88

D2618 Manufactured No

250 Each

153.0000

2 10



Bushing



10/11/2010

Location

Loc Qty

Loc Code

ST019 151
60772 51
62213 100
ST020 2
56892 1
57829 1

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Page 4

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Work Order ID: 63510

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LF.

Start Date: 11/3/2010

Required Date: 1/4/2011

Start Qty: 5.00

Required Qty: 5.00

D2856-400 Manufactured No

250 f

175.2500 0.6

3



Abraison Strip



10/11/24 S P to →

Location

Loc Qty

Loc Code

ST403

175.2500421

56626

0.00004211

59920

175.25

D3235-1 Manufactured No

250 Each

57.0000 2



Mounting Lug



10/11/24 S B62210

Location

Loc Qty

Loc Code

ST471

57

60851

20

61845

37

D3278-041 Manufactured No

250 Each

62.0000 1



Support Assembly



10/11/24 S 5

Location

Loc Qty

Loc Code

ST471

62

61212

32

62393

30

MS21042L3 Purchased No

250 Each

1,890.000 2



Nut



10/11/24 S 10

Location

Loc Qty

Loc Code

ST300

1890

114784

890

115835

1000

10

W/O: 63510		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/11/22	#100	perm. change ADD cut to length 720" to part detail for D8656-410-720	MA	10.11.20			S 10/11/22	

Part No: D330-591-311 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 11/3/2010

Required Date: 1/4/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L4

Purchased

No

250

Each

2,781.000

8

40



10/11/24 sl

Nut

Location

Loc Qty

Loc Code

ST300

2781

113422

25

114523

8

115589

1648

115621

1100

40

MS21042L5

Purchased

No

250

Each

747.0000

2

10



10/11/24 sl (se)

Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

721

115156

221

115594

500

70

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DESIGN <i>QP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *43540*

21-10-03

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Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

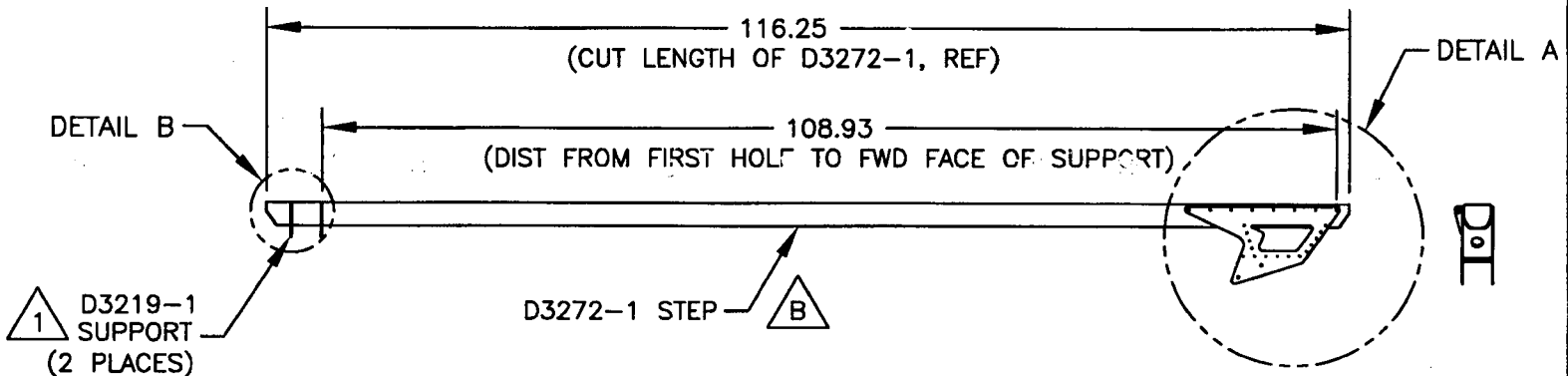
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

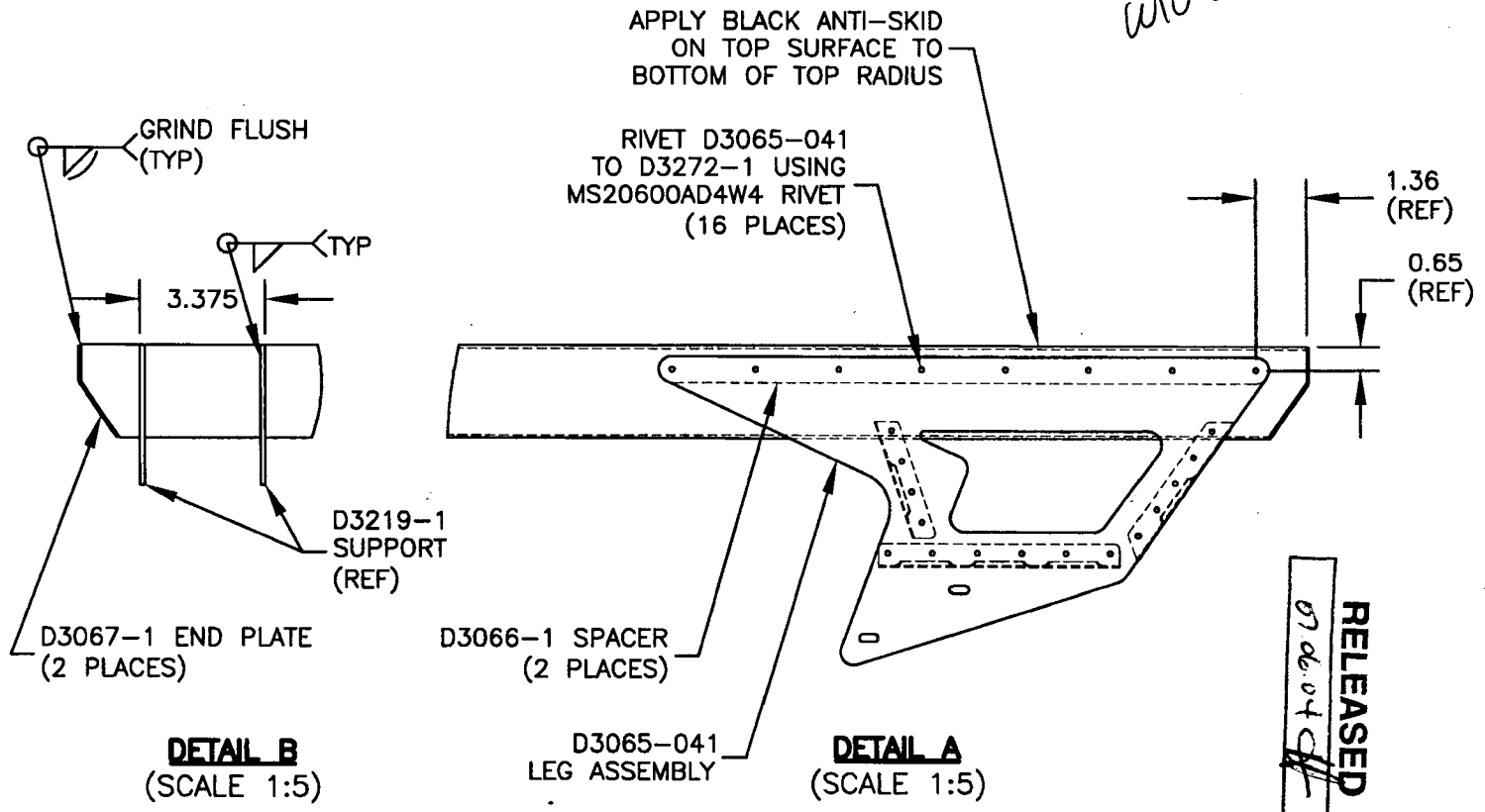


DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. B
07.05.18	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE
		1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

w/o 43510



RELEASED
07.06.04

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

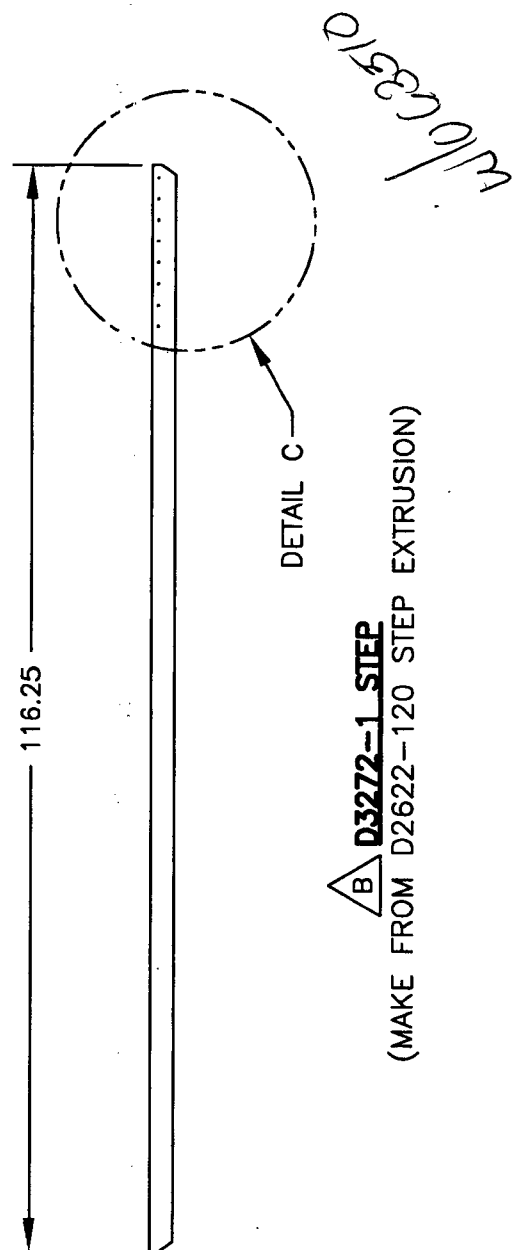
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

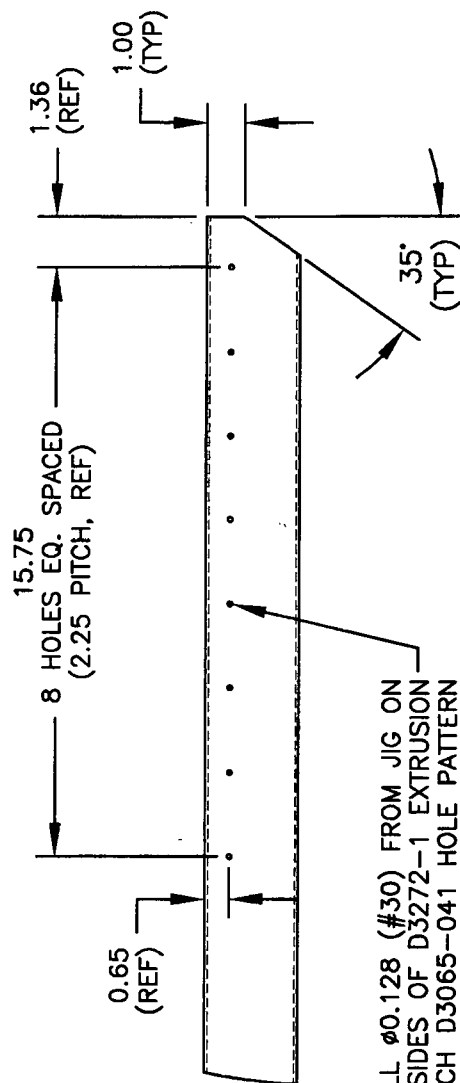
NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

RELEASED

07.06.04 *[Signature]*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

D350-591
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: G
Date: 08.10.06